

IN THE CLAIMS

Please amend the claims as follows.

1. (Currently Amended) A method for producing a composite product comprising a plastic body and a covering layer formed from a metal blank which at least over part of its surface is stuck to the plastic body, ~~wherein~~ comprising

- placing the metal blank (5) ~~is placed~~ in a die, ~~which the~~ the die comprises a blank holder (24), a mandrel (22) ~~which can move~~ movable with respect to the blank holder, and a support die (21),
- closing the die ~~is closed~~, so that the support die (21) and the mandrel (22) are located on either side of the metal blank (5), and the metal blank (5) is supported in the vicinity of its edge with the aid of the blank holder (24),
- injecting a liquid plastic (10) ~~is injected~~ into the die, the liquid plastic (10) being brought into contact with the ~~preformed~~ metal blank,
- converting the liquid plastic (10) ~~being converted~~ into a solid plastic body which is stuck to the ~~preformed~~ metal blank ~~in order~~ to produce the composite product,
- removing the composite product ~~is removed~~ from the die ;

~~wherein the liquid plastic is injected into the die under pressure, during which process the metal blank is shaped.~~

2. (Currently Amended) The method as claimed in claim 1, ~~in which~~ wherein the metal blank is supported in the blank holder in the vicinity of its edge, and ~~in which~~ the metal blank, after the die has been closed and before the liquid plastic is injected, is mechanically preformed with the aid of the mandrel, the mandrel being moved in relative motion along the blank holder toward the support die.

3. (Currently Amended) The method as claimed in claim 1 ~~or 2~~, ~~in which~~ wherein the liquid plastic is injected into the die under pressure, the entire available space being filled with the liquid plastic.

4. (Currently Amended) The method as claimed in ~~one of the preceding claims~~ claim 3, ~~in which~~ wherein the pressure is at least 200 bar and at most 4000 bar, ~~preferably at least 400 bar, more preferably at least 800 bar and even more preferably at least 1200 bar.~~

5. (Currently Amended) The method as claimed in ~~one of the preceding claims~~ claim 1, ~~in which~~ wherein the liquid plastic is injected into the die at a liquid plastic flow rate of at least $10 \text{ cm}^3/\text{s}$, ~~preferably of at least $20 \text{ cm}^3/\text{s}$.~~

6. (Currently Amended) The method as claimed in ~~one of the preceding claims~~ claim 1, ~~in which~~ wherein during the preforming of the metal blank, the metal blank is clamped between the mandrel and the support die, and the support die is moved together with the mandrel.

7. (Currently Amended) The method as claimed in ~~one of the preceding claims~~ claim 1, in which wherein the mandrel and the support die are moved apart before or during the injection of the liquid plastic.

8. (Currently Amended) The method as claimed in ~~one of the preceding claims~~ claim 1, in which wherein during the injection of the liquid plastic the latter is also brought into contact with an end edge of the ~~preformed~~ metal blank which is preformed.

9. (Currently Amended) The method as claimed in ~~one of the preceding claims~~ claim 1, in which wherein the metal blank, at least during preforming, is held in ~~the~~ a grip, which is closed by spring force, of a holding-down clamp which is present in the blank holder.

10. (Currently Amended) The method as claimed in ~~claims~~ claim 1 and 9, wherein the metal blank, at least during the injection of the liquid plastic, is held in ~~the~~ a grip, which is closed by spring force, of the holding-down clamp.

11. (Currently Amended) The method as claimed in claim 9 ~~or 10~~, wherein the spring force is selected to be such that the metal blank is pulled out of the grip of the holding-down clamp and in the process is subject to a certain resistance.

12. (Currently Amended) The method as claimed in ~~one of the preceding claims~~ claim 1, in which wherein, after the liquid plastic has been injected into the die, additional material is injected into the die in at least one after-molding step.

13. (Currently Amended) The method as claimed in ~~one of the preceding claims~~ claim 1, in which wherein the metal blank is selected from a group of types of metal consisting of steel, stainless steel, galvanized steel, tin-plated steel, chrome-plated steel, copper-plated steel, Ni-coated steel, aluminum, and alloys based on a member selected from the group consisting of aluminum, copper, zinc, nickel, brass, bronze, silver, gold, and titanium.

14. (Currently Amended) The method as claimed in ~~one of the preceding claims~~ claim 1, in which wherein the plastic is selected from a group of types of plastic consisting of PP, PET, PE, ABS, PMMA, SAN, PC, PA, PU, PUR, SAN and copolymers thereof, ~~if desired~~ optionally filled with a pulverulent filler, ~~such as ceramic and/or metallic particles,~~ or optionally filled with foaming agents.

15. (Currently Amended) The method as claimed in ~~one of the preceding claims~~ claim 1, in which wherein the metal blank is provided with a plastic coating layer ~~which can preferably be fused to the injected plastic, such as PET, PP or holographic material.~~

16. (Currently Amended) The method as claimed in ~~one of the preceding claims~~ claim 1, in which wherein the liquid plastic is injected into the die under pressure and the metal blank is cut under the influence of the pressure with which the liquid plastic is forced into the die.

17. (Currently Amended) The method as claimed in ~~one of the preceding claims~~ claim 1, ~~in which~~ wherein the metal blank, before ~~it~~ the metal blank is placed into the die, is provided with means, ~~such as a layer of wax~~, to ensure that the plastic body can only stick to the blank over part of the blank.

18. (Currently Amended) A device for producing a composite product which comprises a plastic body and a covering layer formed from a metal blank, ~~which~~ the covering layer, at least over part of its surface, is stuck to the plastic body, ~~which~~

the device comprises a die, ~~which~~ the die is provided with a blank holder (24) for the metal blank (5) to be placed and supported in close to its edge, means for closing the die, a support die and a mandrel (22) ~~which can move~~ movable in relative terms along the blank holder toward the support die, and means for injecting a liquid plastic (10) into the die, in such a manner that the liquid plastic comes into contact with the metal blank, ~~wherein the support die is provided with an uneven support die surface in order to interact with the composite product to produce a defined shape on the composite product.~~

19. (Currently Amended) The device as claimed in claim 18, ~~characterized in that~~ wherein the device comprises means for melting the plastic before injecting the plastic in liquid form into the die, and means for solidifying the liquid plastic in contact with the metal blank.

20. (Currently Amended) The device as claimed in claim 18 ~~or 19~~, ~~characterized in that~~ wherein the support die ~~can move~~ is movable with the mandrel, and the metal blank ~~can be clamped~~ is clampable between the support die and the mandrel.

21. (Currently Amended) The device as claimed in ~~one of claims 18 to 20~~ claim 18, ~~characterized in that~~ wherein the support die and the mandrel, during operating of the means for injecting the plastic into the die, ~~can be moved~~ are movable away from one another.

22. (Currently Amended) The device as claimed in ~~one of claims 18 to 21~~ claim 18, ~~characterized in that~~ wherein the blank holder comprises a holding-down clamp which has a grip ~~which can be closed~~ closable by spring force ~~in order~~ to hold the metal blank.

23. (Currently Amended) The device as claimed in ~~one of claims 18 to 22~~ claim 18, ~~characterized in that~~ wherein the mandrel is provided with an uneven mandrel surface ~~in order~~ to interact with the composite product to produce a defined shape on the composite product.

24. (Currently Amended) The device as claimed in ~~one of claims 18 to 23~~ claim 18 for carrying out ~~the method as claimed in claim 16, characterized in that~~ a method for producing a composite product comprising a plastic body and a covering layer formed from a metal blank which at least over part of its surface is stuck to the plastic body, wherein

- placing the metal blank in a die, which die comprises a blank holder, a mandrel movable with respect to the blank holder, and a support die,
- closing the die, so that the support die and the mandrel are located on either side of the metal blank, and the metal blank is supported in the vicinity of its edge with the aid of the blank holder,

- injecting a liquid plastic into the die, the liquid plastic being brought into contact with the metal blank,
- converting the liquid plastic into a solid plastic body which is stuck to the metal blank to produce the composite product,
- removing the composite product from the die, wherein the liquid plastic is injected into the die under pressure and the metal blank is cut under the influence of the pressure with which the liquid plastic is forced into the die,
wherein the support die is provided with a recessed section with a cutting edge.

25. (Currently Amended) A composite product produced with the aid of the method as claimed in ~~one of claims 1 to 17, and/or the device as claimed in one of claims 18 to 24~~ claim 1, ~~characterized in that~~ wherein the blank has a thickness of between 0.01 mm and 3.0 mm; ~~preferably between 0.03 mm and 1.0 mm, more preferably between 0.05 mm and 0.5 mm.~~

26. (Currently Amended) A composite product produced with the aid of the method as claimed in claim 17, ~~characterized in that~~ wherein the plastic body is only stuck to the metal blank over part of the blank, ~~in order to form an element which can move~~ is movable with respect to the blank, ~~such as a securing element, a resilient element, a click-fit element, a closure element or a pivoting element.~~

27. (Currently Amended) A composite product produced with the aid of the method as claimed in claim 16, ~~characterized in that~~ wherein a section of the metal blank is cut out and is connected to the remainder of the blank by ~~means of~~ a thickened plastic portion.

28. (Currently Amended) The composite product as claimed in claim 27, ~~28 or 29,~~
~~characterized in that wherein~~ the product is a component for a consumer packaging product, ~~such~~
~~as a cover, cap or closure, an (electronics) housing, a bodywork component, an interior~~
~~component for the automotive industry, a catering product, or a computer accessory.~~

29. (New) The method as claimed in claim 1, wherein the liquid plastic is injected
into the die under pressure, during which process the metal blank is shaped.

30. (New) The method as claimed in claim 1, wherein the liquid plastic is injected
into the die at a liquid plastic flow rate of at least 20 cm³/s.

31. (New) The method as claimed in claim 1, wherein the plastic is selected from a
group of types of plastic consisting of PP, PET, PE, ABS, PMMA, SAN, PC, PA, PU, PUR,
SAN and copolymers thereof, optionally filled with a pulverulent filler, selected from the group
consisting of ceramic and/or metallic particles, or optionally filled with foaming agents.

32. (New) The method as claimed in claim 1, wherein the metal blank is provided
with a plastic coating layer fused to the injected plastic

33. (New) The method as claimed in claim 1, wherein the metal blank is provided
with a plastic coating layer fused to the injected plastic selected from the group consisting of
PET, PP and holographic material.

34. (New) The method as claimed in claim 1, wherein the metal blank, before the
metal blank is placed into the die, is provided with a layer of wax to ensure that the plastic body
can only stick to the blank over part of the blank.

35. (New) The device as claimed in claim 18, wherein the support die is provided with an uneven support-die surface to interact with the composite product to produce a defined shape on the composite product.

36. (New) A composite product produced with the aid of the method as claimed in claim 17, wherein the plastic body is only stuck to the metal blank over part of the blank, to form an element movable with respect to the blank, the element selected from the group consisting of a securing element, a resilient element, a click-fit element, a closure element and a pivoting element.

37. (New) The composite product as claimed in claim 27, wherein the product is a component for a consumer packaging product selected from the group consisting of a cover, cap or closure, an (electronics) housing, a bodywork component, an interior component for the automotive industry, a catering product, and a computer accessory.

38. (New) The method as claimed in claim 1, wherein the metal blank the liquid plastic contacts is a preformed metal blank, wherein a cavity has been formed in the preformed metal blank, and during the injection of the liquid plastic the cavity formed in the preformed metal blank is partly filled with the mandrel.

39. (New) The method as claimed in claim 1, wherein the metal blank is a non-preformed metal blank to which the layer of plastic is applied in the form of a recess in the mandrel.

40. (New) The method as claimed in claim 1, wherein the liquid plastic is injected into the die, the liquid plastic being brought into contact with the metal blank which has been preformed.